



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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69812-01
Job Sheet 211372



Part No: 69812-01

Job Qty: 1 pcs

Part Name: Basket Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/15/20

Job Tracking No:

Due Date: 8/3/20

Created By: Linda Lacelle

Type: SOLD

Description:

Note: 69812 REV.4 IPP REV:A 20.07.09 NEW ISSUE DD VERF:JFS

Shlp Via:

Bill of Materials

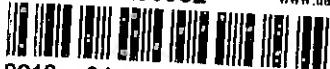
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	8/1/20		0.00	8.00	Large Fab - 1		DAS 24 9-89
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	8/1/20		0.00	0.00	QC 9 - 10		PD 20-8-Y
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	8/1/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

ART
EROSPACE

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CANADA
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Part No: S290962



69812-01

: 211372

Lot/Batch: S290962
REV.4

Ins: TC STC SH00-48 Issue 11 dated 19/12/17, FAA STC SR0

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PTO

					QC 5 - 9	PD 20-8-7
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
130 Powdercoat - 2 White GI(S)- B4B 17254469	1 pcs	8/1/20	0.00 0.25		Powdercoat - 1 - B4B	
START: 10:20					Powdercoat - 2 - B4B	
O.U.T. 400					Powdercoat - 3 - B4B	20-8-5 9-88
FINISH 10:50					Powdercoat - 4 - B4B	
					Powdercoat - 5 - B4B	
					Powdercoat - 6 - B4B	
					Powdercoat - 7 - B4B	
					Powdercoat - 8 - B4B	
					Powdercoat - 9 - B4B	
					Powdercoat - 10 - B4B	
140 QC 3	1 pcs	8/1/20	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	AUG 10 2020
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
150 Small Fab - 2 - B4B	1 pcs	8/3/20	0.00 0.50		Small Fab - 1 - B4B	
N/R					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	AUG 10 2020
					Small Fab - 6 - B4B	DAS 21 9-88
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
160 QC 5	1 pcs	8/3/20	0.00 0.00		QC 5 - 10	DAS 21 9-88
N/R					QC 5 - 12	
					QC 5 - 17	AUG 10 2020
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	

					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
180	Packaging 3-1 - Stock - B4B	1	8/3/20	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
190	QC 21 - SA	1	8/3/20	0.00 0.00	QC 21 - SA - 21	
	pcs				QC 21 - SA - 70	
					QC 21 - SA - 9	
					QC 21 - SA - 77	

AUG 10 2020

DAS
21
9-89

AUG 10 2020

Part Op 100 - Weld per dwg A/R ER70S-2 rod Batch: 139072 1- CUT RIBS AS PER DWG 2- Weld as per dwg ***Visual inspect
 Descriptions: before welding mesh*** 3-Cut mesh as per dwg. 4- Tack weld mesh as per dwg . ***Make sure to place mesh correctly on
 lid*** 5-Clean basket lid and prepare for powder coating.
 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O)

130 - White gloss per QSI005 4. Start Time: _____ Oven Temperature: _____ Finish Time: _____

140 - (QC3- Inspect Part Finish)

150 - 1-Transfer drill tread plate onto basket lid. 2-Deburr holes. 3-Seal faying surfaces with clear RTV and rivet tread plate to basket ribs as per drawing. See note 10. RTV batch; M _____

160 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: _____) See note 6.

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
36204-10	Placard Bracket <i>w/o</i>	1 pcs (1 ea)	100-Large Fab - Basket - 1	<i>5289351</i>
49216-01	Spacer <i>w/2ke</i>	2 pcs (2 ea)	100-Large Fab - Basket - 1	<i>5288913</i>
D5785-041	Handle Hinge <i>sth</i>	2 pcs (2 ea)	100-Large Fab - Basket - 1	<i>5259792</i>
M4130NTS0.750W.035	4130 Square Tube 0.750 X 0.035W	22 ft (22 ea)	100-Large Fab - Basket - 1	<i>5250794</i>
M569EX0.75-16F	569 Expanded Metal Mesh	16 sf (16 ea)	100-Large Fab - Basket - 1	<i>5250794</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	36204-10	1	0	0
	49216-01	2	0	0
	D5785-041	2	2	0
	M4130NTS0.750W.035	22	649	0
	M569EX0.75-16F	16	1,033	0

Part Specifications

Specifications could not be found.

Plex 7/15/20 10:04 AM dart.lacelle.linda

016690

Entered: UR Date: AUG 27 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8384

Route update only ☐

Job: <u>211372</u> Part No. <u>69312-D1</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☒ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
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Date: 20/7/15 Sequence #: 100 QTY Affected: 1 MRB (QSI042) WSP 12 4/20/15

Description Work Order Deviation	Disposition	Completed By									
Substitute: <table border="0"> <tr> <th>Aero PIN</th> <th>DART PIN</th> <th>DESC.</th> </tr> <tr> <td>3/4-16F</td> <td>M56940.75-16F</td> <td>MESH</td> </tr> <tr> <td>84263-01</td> <td>D5785-041</td> <td>HANDLE BRACKET</td> </tr> </table>	Aero PIN	DART PIN	DESC.	3/4-16F	M56940.75-16F	MESH	84263-01	D5785-041	HANDLE BRACKET	Acceptable. DART parts are are functionally identical to the Aero Design parts they replace.	Lead hand / Supervisor 2020/08/10
Aero PIN	DART PIN	DESC.									
3/4-16F	M56940.75-16F	MESH									
84263-01	D5785-041	HANDLE BRACKET									
		QC / QA Coordinator <u>D</u> 20-08-13									

Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☒ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☒ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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Other/Details:																													